

# Work Order ID 60179

Monday, June 28, 2010 1:30:44 PM



Page 1

Item ID: D3836-042

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, RH)

Stop



Start Date: 6/28/2010 Start Qty: 2.00



Required Date: 7/2/2010 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

*R*

Date:

*10-07-08*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3836	Rev A								

100



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1- cut D3836-2 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

*SAD*

*10-07-08*

4- weld D3836-2 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: *11679*

6- grind weld flush where indicated on dwg

*2* *CP 10-07-08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC9- Inspect visual per QS1004- Fusion Welds

0.00

Memo

0.00

② PD 0.07.09

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8.06.09

x2

04/

150



Packaging

Packaging

Identify as per dwg & Stock Location: Basket

0.00

Memo

0.00

② PD 0.07.09

W/O:		WORK ORDER CHANGES					
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**Work Order ID 60179**

Monday, June 28, 2010 1:30:44 PM



Page 3

Item ID: D3836-042

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Stop



Start Date: 6/28/2010 Start Qty: 2.00

Required Date: 7/2/2010 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

100705

MF

10-7-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 28, 2010 1:30:48 PM

Page 1

Work Order ID: 60179

Parent Item: D3836-042

Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 6/28/2010

Required Date: 7/2/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:eC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-3 Spacer Bushing		Manufactured	No			100	Each	11.0000	1	2			
---------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

WA	11	
58406	1	
58974	10	

M304TS0.750W.065 304 SQ Tube .75x.75x.065W		Purchased	No			100	f	617.4786	1.7808	3.749053			
---	--	-----------	----	--	--	-----	---	----------	--------	----------	--	--	--

Location Loc Qty Loc Code

MAT	1.4628	
112398	0	
114482	1.4628	
WA	616.015785	
114520	616.015785	

*Cpl 1007-08*

*B599808 → 2*

*SAP 10-07-08*

*3.7491*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

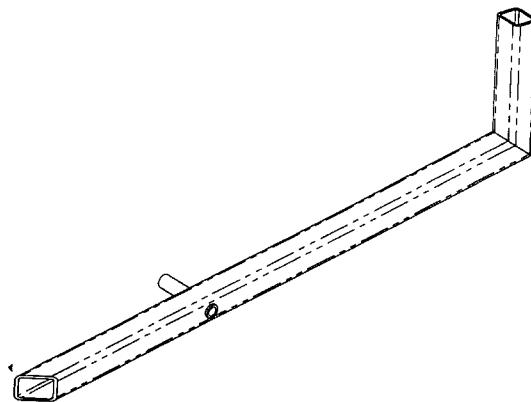
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

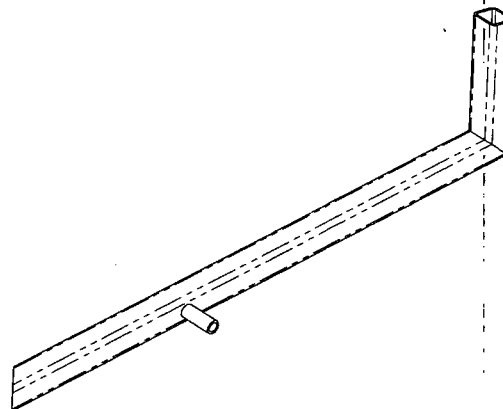
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**NOTE:** Date & initial all entries





**D3836-042 RIB ASSY (BASKET LID, RH)**



**D3836-041 RIB ASSY (BASKET LID, LH)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs EACH
- 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 60179  
2810-6-25

**RELEASED**  
08/11/14

A	NEW ISSUE		MB	08.09.24
REV.		DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.09.24			

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3836</b>	REV. A
TITLE <b>RIB ASSY (BASKET LID)</b>	SHEET 1 OF 3
SCALE NTS	

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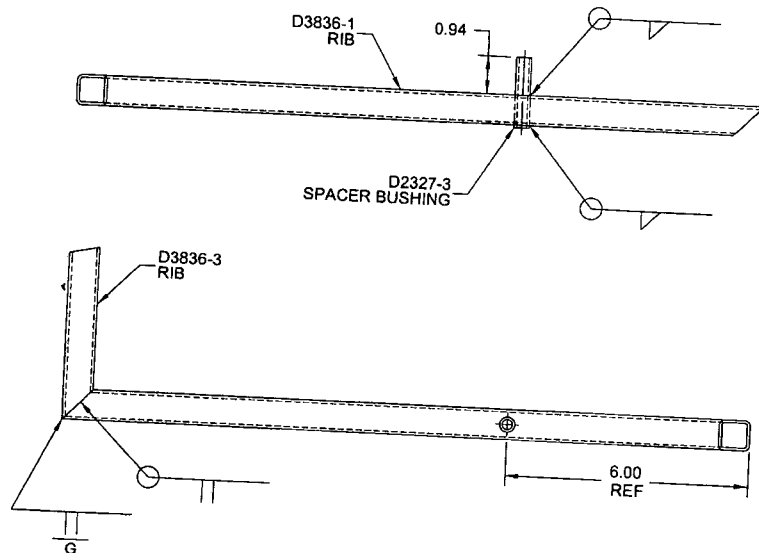
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

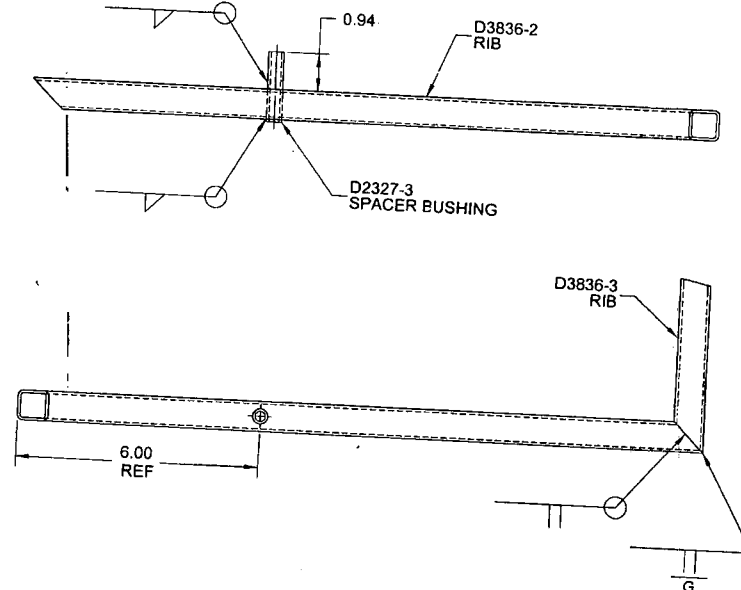
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**NOTE:** Date & initial all entries



**D3836-041 RIB ASSY (BASKET LID, LH)**



**D3836-042 RIB ASSY (BASKET LID, RH)**

*w/o 60179*

**RELEASED**  
08/11/18

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. <b>D3836</b>
MFG. APPR.		REV. A
APPROVED		SHEET 2 OF 3
DE APPR.		TITLE <b>RIB ASSY (BASKET LID)</b>
DATE <b>08.09.24</b>		SCALE <b>NTS</b>
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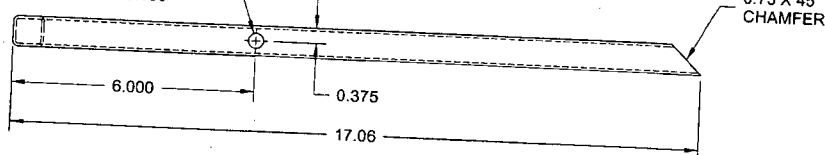
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**NOTE:** Date & initial all entries

0.75 X 45°  
CHAMFER



$\varnothing 0.375^{+0.020}_{-0.000}$  THRU

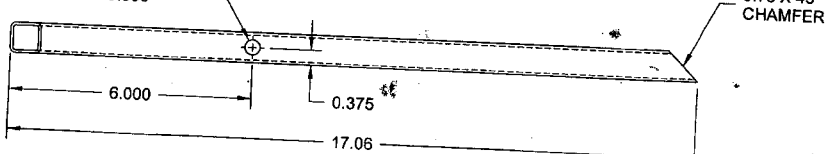


**D3836-1 RIB**

0.75 X 45°  
CHAMFER

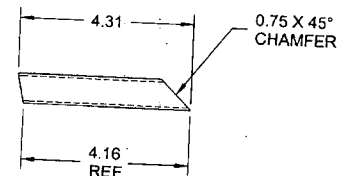


$\varnothing 0.375^{+0.020}_{-0.000}$  THRU

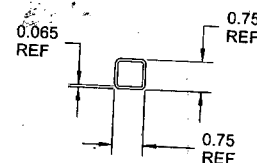


**D3836-2 RIB**

0.75 X 45°  
CHAMFER



**D3836-3 RIB**



**TYPICAL SECTION  
VIEW**

**RELEASED**  
08/11/14

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3836</b> TITLE <b>RIB ASSY (BASKET LID)</b> SCALE NTS
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		REV. A SHEET 3 OF 3
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